

67.364

Dart Aerospace Ltd.

Date: Tuesday, 3/11/2008 7:57:26 AM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: RAPPEL ANCHOR
Job Number	: 37744		
Estimate Number	: 11069		
P.O. Number	:	Part Number	: D2224
This Issue	: 3/11/2008 S.O. No. :	Drawing Number	: D2224 REV E
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : MACHINED PARTS	Drawing Revision	: E
Previous Run	: 27245	Material	:
Written By	:	Due Date	: 3/31/2008 Qty: 5 Um: Each
Checked & Approved By	: <u>JA 08 03 11</u>		
Comment	: Est Rev. 02.04.23 Add note for grain direction & inspect 8, 21 N G		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
---------	-----------------------	--------------

1.0	M7075T73B2500X0325	7075-T73 Bar 2.5 x 3.25"
-----	--------------------	--------------------------



Comment: Qty.: 0.2321 f(s)/Unit Total: 1.1603 f(s)

7075-T73 Bar 2.5 x 3.25"

(M7075T7B0325X0320)

Batch: M102694

2.0	BAND SAW	BAND SAW
-----	----------	----------



Comment: BAND SAW

Cut blanks: 2.660" +.030" / -.010"

\*\*\*\*\*Note grain direction\*\*\*\*\*

JA 08/03/13

3.0	HAAS	HAAS CNC VERTICAL MACHINING #1
-----	------	--------------------------------



Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine as per Folio D2224 &amp; Dwg D2224

2-Deburr &amp; Tumble

JL 08/03/19

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

JL 08/03/19

5.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

SF 08/03/19 (5)

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Tuesday, 3/11/2008 7:57:26 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: RAPPEL ANCHOR

Job Number: 37744

Part Number: D2224

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

OUTSIDE SERV.30

OUTSIDE SERVICES-MACH



Comment: Sub-Contracting OUTSIDE SERVICES

Issue P/O: 5988

Red Anodize as per Dwg D2224 MIL-A-8625

*C208/03/26*

*(5)*

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Recieve & Inspect for Transit Damage

*P 8/4/2 (5)*

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT ANODIZE

*DS 08/04/03 (5)*

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ~~ST20~~

*ST20*

*DS 08/04/04 (5)*  
~~*DS 08/04/03 (5)*~~

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*08/04/08*

Job Completion



*W 08-04-04*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

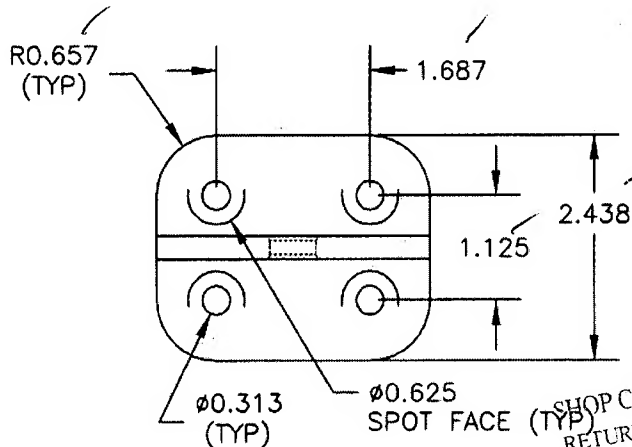
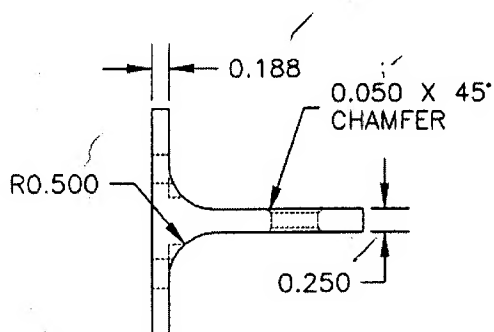
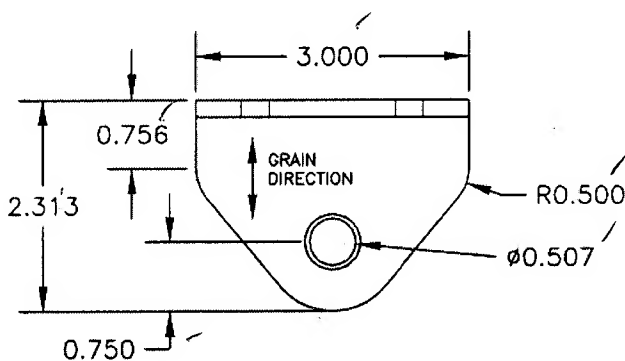
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**DART**

DESIGN <i>[Signature]</i>	DRAWN BY <i>RF</i>	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2224	REV. E SHEET 1 OF 1
DATE 99.04.29		TITLE RAPPEL ANCHOR	SCALE 1:2
A	94.03.10	NEW ISSUE	
B	95.04.11	D2227 WAS D2216	
C	96.06.17	ADDED D2224-60	
D	97.04.25	CHANGE TO T-SHAPE	
E	99.04.29	REVISE MATERIAL SPECIFICATIONS	

**RELEASED**  
99.05.11 KE

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
No. 37744

MATERIAL: 7075-T7351 (QQ-A-200/11) OR 7075-T651 (QQ-A-200/11)  
FINISH : ANODIZE RED PER MIL-A-8625  
BREAK ALL UNMARKED EDGES 0.010 TO 0.020  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



21 chemin de l'Aviation, Pointe Claire QC H9R 4Z2

Telephone: (514) 429-7777 Fax: (514) 429-5108

Certifié ISO 9001-2000 certified

approuvé NADCAP approved

63408

31-Mar-2008

## CLIENT / CUSTOMER:

DART AEROSPACE LTD.

1270 ABERDEEN STREET

HAWKESBURY , ONTARIO

K6A 1K7

CERTIFICATE OF COMPLIANCE  
CERTIFICAT DE CONFORMITENO. DE COMMANDE: 214586  
PURCHASE ORDER/

ITEM	COMMANDE ORDERED	EXPEDIE SHIPPED	PART NUMBER & DESCRIPTION	PART PROCESS & TREATMENT
1	5	5	D2224 B 37744 -	RED ANODIZE PER MIL-A-8625F1 TYPE 1 CLASS 2
2	31	31	D2091 B 30137 -	BLACK ANODIZE PER MIL-A-8625F1 TYPE 1 CLASS 2
3	100	100	D1038-58B B 38022 -	BLACK ANODIZE PER MIL-A-8625F1 TYPE 1 CLASS 2

REQUIREMENTS HAVE BEEN IN ACCORDANCE WITH MD-INC P.R.I.D.E. MANUAL

Nous certifions que les pièces énumérées ont été traitées, testées et inspectées selon les spécifications mentionnées.

Les cartes de travail ont été remplies et sont disponibles pour consultation, sur demande.

All parts are processed, tested, and inspected to the requirements of above specifications.

Travel cards have been filled and are available for viewing upon request.

NOTE: Painted Parts will be Fully Solvent Resistant after 7 (seven) Full Days of Air Curing at Ambient Temperatures"

NOTE: Les pièces peintes seront complètement résistantes au solvant après 7 (sept) jours complets de séchage à l'air ambiant.

Signature/Signed: \_\_\_\_\_  
Directeur de la Qualité / Q.A. Manager